International Journal of Production Technology and Management (LIPTN), ISSN 1976 - 1285 (Penal), ISSN 1976 - 1285 (Penal)

A DESIGN OF EXPERIMENTS AND ANALYSIS

3.3 Design of Experiments

The experimental layout for the muchining parameters using the L_D orthogonal array was used in this study.

Tubble per 3.3	Cl. Deposit	Marchinege.	Postumeters.

8.80	NO INPUT	LEVEL			ORSERVED VALUE	
-			2.	- 3-		Material removal rate.
16.	Current (lg)	30	13	307	200	(MHSE) In. g/min.
2.	Police on time (T _m)	50	100	150	200	
3.	Pulse off time $(T_{\rm eff})$	3		9	12	
46.	Voltagat(V)	20	. 30	40	.50	

This array consists of four control parameters and four levels, as shown in table ms. 3.3.1. In the tagachi method, ment all of the observed values are calculated based on 'higher is the better'. Each experimental trial was performed with those simple explications at each set value. Next, the optimization of the observed values was determined by comparing the standard analysis and analysis of variance (ANOVA) which was based on the tagachi method.

3.2 Results and analysis of MER for machined surface

The efficit of parameters i.e. Current, Pulse on time, Pulse off time and Voltage some of their interactions were evaluated using ANOVA. A confidence interval of 95% has been used for the analysis. To measure Signal to Noise ratio (S/N entire) calculated by the formula

Where MSD₉₀₀ =
$$\frac{1}{r}\sum_{i=1}^{r}(\frac{1}{r^{i}})$$

CS/NO HIR = -10 log (MSD)(HD)

Five material removal rate (MRR) the S/N ratio is larger is better.

Where MSD688 v Moun Square deviation for higher the better response.

3.3 Observation table

During the conduction of all the 16 experiments with different set of input parameters observation were made for the weight host in the grain from the workpiece in each experiment and three taken in the minute for the machining of each experiment was also observed. For all the tradings time taken was I hour. After the completion of all the experiments the observation reading of the weight how and time taken were filled in orthogonal array as shown in table 3.3.1

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Christian Drosten

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